

3/4 11303



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D2745**Job Sheet 213089****Part No:** D2745**Job Qty:** 120 pcs**Part Name:** Bushing**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 9/16/20**Job Tracking No:****Due Date:** 10/12/20**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG REV B IPP C 02.03.07 Update to turn in house NG IPP Rev:D 07-10-23 Removed tumbling JLM Verified By:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Hardinge - 1	120 pcs	10/12/20	10/12/20	0.01	4.80	Hardinge - 1	W-09-26
120	QC 8	120 pcs	10/12/20	10/12/20	0.00	0.00	QC 8 - 12	
							QC 8 - 14	20/09/27
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
							QC 8 - 57	
							QC 8 - 76	
							QC 8 - 61	
							QC 8 - 66	
							QC 8 - 73	



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Container No: S303141**Part:** D2745**Job No:** 213089**Serial No/Batch:** S303141**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 09/26/20

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				QC 8 - 82		
130	Packaging 3-1 - Stock - B4B	120 pcs	10/12/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
				Packaging 3 - 37 - B4B		
140	QC 21 - SA	120 pcs	10/12/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70		
				QC 21 - SA - 9		
				QC 21 - SA - 77		
				QC 21 - SA - 28		

DAS
84
9-89

SEP 29 2020

DAS
21
- 28

SEP 29 2020

FPool

DAS
84
9-89

SEP 29 2020

FP001

DAS
21
9-89

SEP 29 2020

Part Op 100 - 1-Turn as per FOLIO FA201 FOLIO REV: 11A DWG REV: B 2-DEBURR
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: _____) LOCATION : FP001
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.750	303 Round Bar 0.750	11.0400 ft (.092 ea)	100-Hardinge - 1	5302988

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M303R0.750	11	1	0

72

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.060inches $\pm$ 0.010	0.070 0.050	.059	
2	Bushing	0.400inches $\pm$ 0.010	0.410 0.390	.4	
3	Bushing	0.060inches $\pm$ 0.010	0.070 0.050	.059	
4	Bushing	1.020inches $\pm$ 0.010	1.030 1.010	1.021	
5	Bushing	0.030inches $\pm$ 0.010	0.040 0.020	.032	
6	Bushing	20.000Degrees $\pm$ 0.000	20.000 20.000	20	
7	Bushing	0.472inches $\pm$ 0.010	0.482 0.462	.472	
8	Bushing	0.375inches + 0.006 - 0.001	0.381 0.374	.376	
9	Bushing	0.560inches $\pm$ 0.010	0.570 0.550	.56	
10	Bushing	0.750inches $\pm$ 0.010	0.760 0.740	.745	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					